

Date: - Wednesday, 2/15/2006 3:46:17 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING BRACKET
Job Number : 25834	
Estimate Number : 10604	
P.O. Number : N/A	Part Number : D2581
This Issue : 2/15/2006 S.O. No. : N/A	Drawing Number : D2581 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A1
Previous Run : 25139	Material : N/A
Written By : <u>See COMMENT BELOW</u>	Due Date : 3/2/2006 Qty: 52 Um: Each
Checked & Approved By : <u>06.02.16</u>	
Comment : Est. D 01.07.17 Added info to step 2 SM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 603

Laser cut as per Dwg D2581

Material: 304/316 SS 0.125" thick

Material release note required

u 06-02-16 52

2.0	D2581F	Mounting Bracket
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Comment: Qty.: 1.0000 U(s)/Unit Total : 52.0000 U(s)
 Mounting Bracket

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

C 204/03/09 52

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

06.03.16

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Deburr

SAN 06.03.12 52

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 26/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:46:17 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING BRACKET

Job Number: 25834

Part Number: D2581

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2581 using CNC Brake

SB

06/03/13

52

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-03-13

52

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

06-03-13

51

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06-03-14 (52)

Job Completion



u 06-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

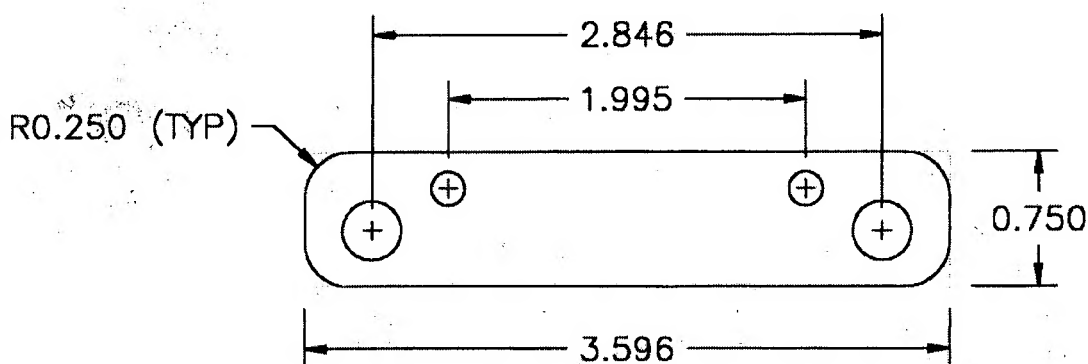
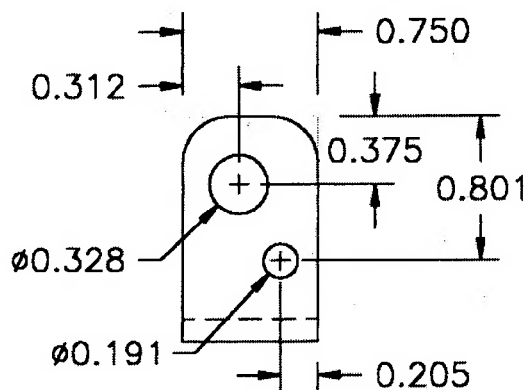
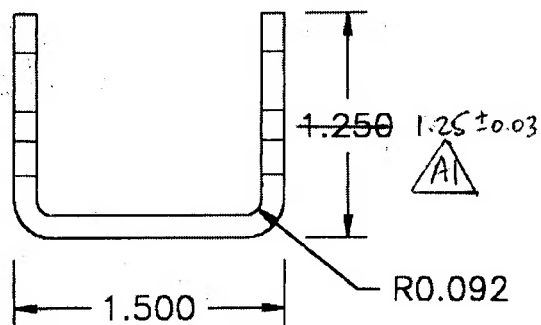
NOTE: Date & initial all entries

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	MIKE M	DRAWING NO.	REV. A
CHECKED	APPROVED	D2581	SHEET 1 OF 1
DATE		TITLE	SCALE
96.06.27		MOUNTING BRACKET	1:1
AI	CP 04.05.14	CHANGE TOLERANCE ON 1.25 DIMENSION	

RELEASED
96/07/23 BW



MATERIAL: 304/316 SS 0.125 THICK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25834

P57020PC002

OCT-20-2005 15:06

OLBERT METAL SALES

905 705 1320

P.02/2

WILKINSON STEEL AND METALS

PS1020PC002V

00000004-001 200005
Pg 1/1STAINLESS OR COIL 304
114 X 48 0003
NO.

Certified in accordance to Pressure Equipment Directive 97/23/EC Annex
Paragraph 4.3 by TÜV Aulagetechnik GmbH (Notified Body Identification No.0035)
Inspection Certificate EN10204-3.1B

Shanxi Taigang Stainless Steel CO.,LTD Member
of Taiyuan Iron and Steel (Group) Co.,LTD

NO.2 Jiansheping, Taiyuan, Shanxi, P.R.China
TEL: (0351)3013328 FAX: (0351)3017816
http://www.tisco.com.cn
E-mail: tgbxg@tisco.com.cn

MILL TEST CERTIFICATE

MATERIAL	AISI304 No.2B Finish	
SPECIFICATION	ASTM A240/A480	ASME SA240/SA480
L/C NO.		
CERTIFICATE NO.	20050636	
DATE OF ISSUE	11	

CUSTOMER		CONTRACT NO.		DATE OF	
OLBERT		1149		20050620	
Product		Molding furnace	Inspector's stamp	Mark of the Manufacturer	
COIL	E+VOD		Shanxi Taiyuan Stainless Steel Co., Ltd		

NO.	Heat No.	Coil No.	Quantity	Dimensions			Weight (kg)
8	QBP1133	5A4-278-4ZB	1	20GA	x 48	x C	8528
9	Y501898	5A4-419-4ZY	1	14GA	x 48	x C	5396
10	4501977	5A4-348-1ZB	1	11GA	x 48	x C	5182
11	4501969	5A4-416-4ZY	1	14GA	x 48	x C	7709
12	4501968	5A4-415-4ZY	1	14GA	x 48	x C	7495
13	4501965	5A4-367-1ZB	1	11GA	x 48	x C	8127
14	4500491	5A5-18-4ZJ	1	20GA	x 48	x C	7868

Chemical Composition

Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
QBP1133	0.049	0.470	1.090	0.023	0.003	18.340	8.050				0.039
Y501898	0.038	0.430	1.000	0.029	0.004	18.420	8.070				0.066
4501977	0.070	0.470	1.310	0.019	0.002	18.050	8.100				0.050
4501969	0.030	0.430	1.270	0.018	0.002	18.020	8.010				0.050
4501968	0.060	0.460	1.350	0.018	0.003	18.120	8.100				0.050
4501965	0.050	0.440	1.320	0.019	0.002	18.140	8.090				0.050
4500491	0.050	0.500	1.340	0.020	0.002	18.040	8.060				0.050

Mechanical Properties

Tem No.	Tensile R _m N/mm ²	R _{0.2} Yield _{0.2%} N/mm ²	R _{0.01} Yield _{0.01%} N/mm ²	Elongation A5%	Corrosion Tests	Hardness		
						HRB	HV	HRC
QBP1133-T	670	290		55			175	
Y501898-T	665	289		60		83		
4501977-T	615	279		60		86		
4501969-T	655	298		61		84		
4501968-T	658	294		58		84		
4501965-T	690	283		60		85		
4500491-T	660	329		60			172	

Surface and dimensions controlled: O.K.

Work Inspection

Page: 2 of 3

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TOTAL P.02